Work Order ID 62246

Wednesday, September 22, 2010 3:39:14 PM

Item ID: D2151 **Accept** **Setup Start**

Revision ID: **Stop**

Item Name: Packer Doubler, Hinge

Start Date: 9/22/2010 **Start Qty:** 20.00 **Cust Item ID:**

Required Date: 9/30/2010 **Req'd Qty:** 20.00 **Customer:**

Reference:

Approvals: **Process Plan:** M **Date:** 10-9-23 **Tooling:** _____ **Date:** _____ **Run Start**

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____ **Stop**

Draw Nbr	Revision Nbr
D2151	Rev B

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
100	FLOW WATER JET	0.00							
Waterjet	**Memo**	0.00							
FLOW CNC Waterjet	1-Cut as per Dwg D2151 ☐Dwg Rev: B ☐Prog Rev: B ☐2-								
3634 .040	Deburr if necessary								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
QC	**Memo**	0.00							
Quality Control									
120	QC8- Inspect parts - second check	0.00							
QC	**Memo**	0.00							
Quality Control									

10-9-23

38

10-9-23

10/02/23

counted

x38

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Work Order ID 62246

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Start Date: 9/22/2010 **Start Qty:** 20.00 **Cust Item ID:**

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QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____ **Stop**

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Small Fab	0.00							
Small Fab	**Memo**	0.00							
Small Fab	Deburr w/ AE								
140	Chemical Conversion Coat per QSI005 4.1	0.00 10-9-30				38	4		
HandFinish	**Memo**	0.00							
Hand Finishing									
150	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00 10-10-4				38	4		
Powdercoat	M115291								
Powder Coating	**Memo**	0.00							
	START TIME: 10:25 ☐OVEN TEMPERATURE: 390° ☐FINISH TIME: 10:55								

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W/O:		WORK ORDER CHANGES					
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Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

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NOTE: Date & initial all entries

Work Order ID 62246

Wednesday, September 22, 2010 3:39:14 PM

Item ID: D2151 **Accept** **Setup Start**

Revision ID:

Item Name: Packer Doubler, Hinge **Stop**

Start Date: 9/22/2010 **Start Qty:** 20.00 **Cust Item ID:**

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QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____ **Stop**

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC3- Inspect Part Finish	0.00	=) M 10/10/04			38	0		
QC	**Memo**	0.00							
Quality Control									
170	Identify as per dwg & Stock Location: 07	0.00							
Packaging	**Memo**	0.00							
Packaging									
180	QC21- Final Inspection - Work Order Release	0.00							
QC	**Memo**	0.00							
Quality Control									

10/10/04 (38)

10/10/05 DJ

M 10-10-05

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

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NOTE: Date & initial all entries

Picklist Print

Wednesday, September 22, 2010 3:39:19 PM

Work Order ID: 62246

Parent Item: D2151

Parent Item Name: Packer Doubler, Hinge

Start Date: 9/22/2010 **Required Date:** 9/30/2010

Start Qty: 20.00 **Required Qty:** 20.00

Comments: IPP □C□00.10.23□Re-format (mpp 2101)□EC□
IPP Rev:D 06-04-28 Manufactured on Water Jet JLM
IPP Rev:E 06-11-24 As per Rev B JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M2024T3S.040		Purchased	No			110	sf	339.5400	0.035	0.736842	1.7		
2024-T3 .040 sheet											AB 10-9-28		

Location		Loc Qty	Loc Code
MAT		88.1	
	114415	88.1	
MAT22		251.44	
	110305	23.13	
	111786	13.76	
	112291	28.25	
	112331	52	
	113162	134.3	

110305

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W/O:		WORK ORDER CHANGES					
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Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

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NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	42246
Description: Packer	Part Number:	D2151
Inspection Dwg: D2151 **Rev:** B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

[X] First Article [] Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.098	+0.005/-0.000	.101	✓		V HB02	
Ø0.171	+0.005/-0.000	.173	✓		V	
0.231	+/-0.010	.230	✓		V	
1.217	+/-0.010	1.218	✓		V	
2.194	+/-0.010	2.196	✓		V	
2.300	+/-0.010	2.300	✓		V	
1.560	+/-0.010	1.561	✓		V	
0.250	+/-0.010	.252	✓		V	
1.328	+/-0.010	1.329	✓		V	
0.342	+/-0.010	.344	✓		V	
0.740	+/-0.010	.741	✓		V	
2.050	+/-0.010	2.052	✓		V	
0.040	+/-0.010	.040	✓		V	

Measured by:	IB	Audited by:	S	Prototype Approval:	N/A
Date:	10-9-28	Date:	10/09/28	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.08.12	New Issue	KJ/JLM	
B	06.11.24	Dwg Revision revised	KJ/JLM	BE

Dart Aerospace Ltd

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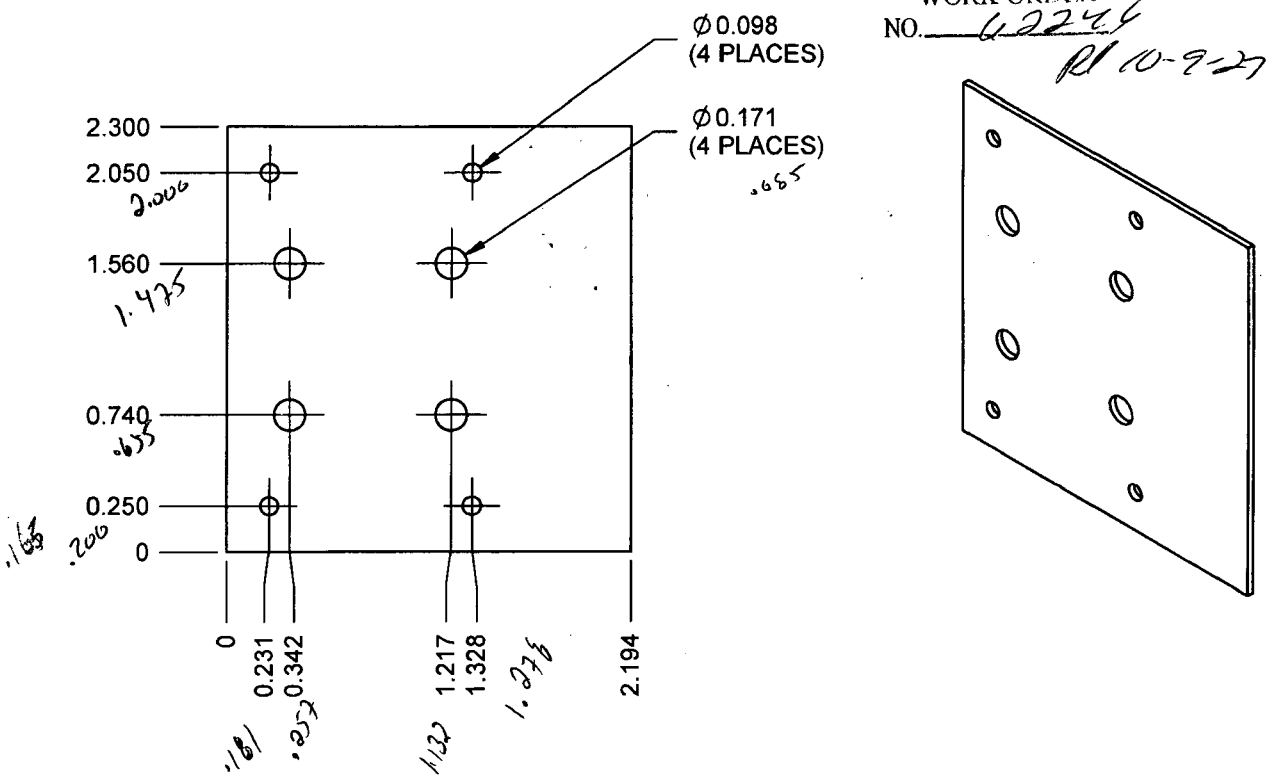
NOTE: Date & initial all entries

DESIGN	DRAWN BY	DART AEROSPACE LTD
BW	CB	HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. REV. B
LE		D2151 SHEET 1 OF 1
DATE		TITLE SCALE
06.10.13		PACKER 1:1

REV	DATE	DESCRIPTION
A	95.05.01	NEW ISSUE
B	06.10.13	UPDATE DRAWING

RELEASED
06.11-20

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 42246
10-9-27



D2151 PACKER

NOTES:
1) MATERIAL: ALUMINUM 2024-T3 SHEET 0.040 THICK PER QQ-A-250/4 OR AMS 4037
(REF DART SPEC M2024T3S.040)
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE GLOSS (4.3.5.1) PER DART QSI 005 4.3
3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
5) BREAK ALL SHARP CORNERS TO 0.010 MAX
6) IDENTIFY WITH DART P/N "D2151" USING FINE POINT PERMANENT INK MARKER

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